

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003611**Date Inspected:** 25-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Tower Shop Bay 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in Tower Shop bay 2 it was noted that ZPMC was in the process of tack welding for the Complete Joint Penetration (CJP) weld joints for the tower skin plates under WPS-B-P-2211-B-U3b by ZPMC welding personnel Cao Jianbin for weld joint ESD1-SA80-A/E-44B. ZPMC had their Certified Welding Inspector An Qing Xiang monitoring the welding and progression along with ZPMC QC personnel for assistance at this location.

89 mock up MT

This QA inspector was notified by day shift personnel that ZPMC had performed their MT inspection on lug plate to diaphragm connection with acceptable results. The day shift had performed their QA verification and discovered linear indication at the toe of the welds. ZPMC had ground these areas and retested the weld number MUB-MA21-A/J-12. This QA inspector then performed his QA review of the weldment with magnetic particle inspection and found no linear indication within the weldment. The weldment appeared to be within compliance at the time of this QA review.

Summary of Conversations:

As stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joush Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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